

5/23

SLIT

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23233 B
<b>Description:</b> Ø3.250 Support	<b>Part Number:</b>	D2940-1
<b>Dwg:</b> D2940 Rev. A1	<b>Qty:</b>	12
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller. Blank size makes (2) D2940-1 Dwg not required	JA	05.05.11	12
2	PG	Issue P/O: 7008035 Description: D6104-007 Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104 Material release note required. ReuB.	JA	05/05/12	12
3	RG	Receive and Inspect for raw material dimensions. Ensure material release note is attached.	CJ	05/05/20	10
4	MS	Turn blank for Haas as per Folio FA079	JG	05/08/16	20
5	QC1	Inspect all dimensions as per Dwg D2940	JG	05/08/16	20
6	MV	Machine as per Folio FA079	SD	05.08.27	12
7	MV	Tumble & Deburr	SD	05.08.27	12
8	QC1	Inspect all dimensions to inspection sheet as per Dwg D2940	SD	05.08.27	12
9	QC8	Inspect dimensions for second check	SD	05.08.27	12
10	FP	Powder Coat White (4.3.5.2) per QSI 005 4.3	FL	05.09.22	12
11	QC3	Inspect Powder Coat	MI	05.09.22	12
12	ST	Identify and stock	CJ	05/09/23	12
13	AC	Cost / part 123.57	54	05.09.26	12
14	DC	Close W/O 134.35 Inspect Level 21	CJ	05/09/24	12

Rev	Date	Change	Revised By	Approved
A	01.01.08	Preliminary Issue	EC	
B	01.08.15	Removed Heat treating	EC	
C	02.11.26	Reformat; Added P/O	KJ	

RELEASED  
02/11/29 RF

J. T. AEROSPACE LTD		Work Order: 23233
Description: Ø 3.250 support		Part Number: A2940-1
Inspection Dwg: A2940	Rev: A1	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☐ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
AA .250	± .010	.250	✓			
AB 500	± .010	.500	✓			
AC .150	± .010	.155	✓			
AD 3.520	± .010	3.525	✓			
AE 1.653	± .020	1.658	✓			
AF 1.503	± .010	1.502	✓			
AG .050	± .010	.046	✓			
AH Ø.188	± .005 - .001	.190	✓			
AI .150	± .010	.146	✓			
AJ 2.528	± .010	2.528	✓			
AK .050	± .010	.049	✓			
AL .010	± .010	.010	✓			
AM .150	± .010	.150	✓			
AN .400	± .050	.425	✓			
AO .250	± .010	.250	✓			
AP .160	± .010	.160	✓			
AQ .063	± .010	.063	✓			
AR 103.64	± .2		✓			
AS Ø.257	± .005 - .001	.259	✓			
AT .063	± .010	.063	✓			
AU 4.128	± .010	4.127	✓			

Measured by: J.L.	Audited by: E	Prototype Approval: CP
Date: 05.08.23	Date: 05.08.23	Date: 05.08.23

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23233
<b>Description:</b> Ø3.250 Support		<b>Part Number:</b>	D2940-1
<b>Inspection Dwg:</b> D2940 Rev. A1		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2940.Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	3.211	3.216		3.213	3.213	3.214	3.214		
B	4.946	4.966		4.956	4.959	4.956	4.956		
C	0.718	0.738		0.728	0.728	0.728	0.728		
D	0.090	0.110		0.110	0.107	0.110	0.110		
E	3.564	3.584		3.575	3.574	3.574	3.574		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.454	3.454	3.454	3.454		
H	0.112	0.132		0.121	0.121	0.120	0.121		
I	2.170	2.190		2.181	2.182	2.182	2.182		
J	4.451	4.471		4.460	4.460	4.459	4.459		
K	0.413	0.433		0.423	0.423	0.422	0.423		
L	0.913	0.933		0.923	0.923	0.924	0.922		
M									
N									
HAAS Section									
AA	0.240	0.260		.250	-.250	.250	-.250		
AB	0.490	0.510		-.500	-.500	-.500	.500		
AC	0.140	0.160		.150	-.152	0.150	0.151		
AD	3.510	3.530		3.521	3.522	3.522	3.526		
AE	1.633	1.673		1.657	1.657	1.657	1.657		
AF	1.493	1.513		1.503	1.500	1.501	1.501		
AG	0.040	0.060		-.049	-.051	0.050	0.050		
AH	0.188	0.193	DT8706	0.147	0.148	0.147	0.142		
AI	0.140	0.160		2.528	2.528	2.528	2.528		
AJ	2.518	2.538		-.047	0.048	0.048	0.048		
AK	0.040	0.060		-.010	-.010	-.010	-.010		
AL	0.010	0.020		-.151	-.148	0.150	0.149		
AM	0.140	0.160		-.425	-.425	0.425	0.425		
AN	0.350	0.450		-.250	-.250	-.250	-.250		
AO	0.240	0.260		-.156	-.155	0.155	0.155		
AP	0.150	0.170		-.063	-.063	-.063	-.063		
AQ	0.053	0.073		101.64	105.64	DT8698			
AR	0.257	0.262	DT8683	✓	✓	✓	✓		
AS	0.053	0.073		-.063	-.063	-.063	-.063		
AT	4.118	4.138		4.127	4.127	4.127	4.127		
AU									
AV									
AW									
Accept/Reject									

Measured by:	S.G. / J.L.
Date:	05/08/19 / 05.08.24

Audited by:	J. / E.
Date:	05/08/16 / 05.08.24

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

RELEASED  
03.07.01 RF

RT AEROSPACE LTD

Work Order:

23233

Description: Ø3.250 Support

Part Number:

D2940-1

Inspection Dwg: D2940 Rev. A1

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
Lathe Section									
A	3.211	3.216		3.211	3.216	3.216	3.215		
B	4.946	4.966		4.955	4.956	4.958	4.957		
C	0.718	0.738		0.728	0.727	0.728	0.727		
D	0.090	0.110		0.110	0.110	0.110	0.110		
E	3.564	3.584		3.574	3.575	3.575	3.576		
F	0.022	0.042		0.032	0.032	0.032	0.032		
G	3.444	3.464		3.454	3.455	3.454	3.455		
H	0.112	0.132		0.121	0.121	0.121	0.121		
I	2.170	2.190		2.181	2.182	2.182	2.182		
J	4.451	4.471		4.460	4.461	4.460	4.460		
K	0.413	0.433		0.422	0.423	0.424	0.423		
L	0.913	0.933		0.923	0.924	0.924	0.923		
M									
N									
HAAS Section									
AA	0.240	0.260		0.250	0.250	0.250	0.250		
AB	0.490	0.510		0.500	0.500	0.500	0.500		
AC	0.140	0.160		0.153	0.149	0.151	0.150		
AD	3.510	3.530		3.517	3.520	3.526	3.521		
AE	1.633	1.673		1.659	1.660	1.660	1.658		
AF	1.493	1.513		1.503	1.510	1.510	1.508		
AG	0.040	0.060		0.051	0.050	0.050	0.050		
AH	0.188	0.193	DT8706	0.188	0.188	0.188	0.188		
AI	0.140	0.160		0.147	0.146	0.148	0.145		
AJ	2.518	2.538		2.528	2.528	2.528	2.528		
AK	0.040	0.060		0.048	0.048	0.046	0.046		
AL	0.010	0.020		0.010	0.010	0.010	0.010		
AM	0.140	0.160		0.153	0.151	0.152	0.150		
AN	0.350	0.450		0.400	0.400	0.400	0.400		
AO	0.240	0.260		0.250	0.250	0.250	0.250		
AP	0.150	0.170		0.166	0.166	0.166	0.166		
AQ	0.053	0.073		0.063	0.063	0.063	0.063		
AR	101.64	105.64	DT8698					No need to measure	
AS	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
AT	0.053	0.073		0.063	0.063	0.063	0.063		
AU	4.118	4.138							
AV									
AW									
Accept/Reject									

Measured by:

J.G

Audited by:

En

Date:

05/08/16

Date:

05/08/16

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	

RELEASED  
03.07.01 RF

RT AEROSPACE LTD	Work Order: 23233
Description: Ø3.250 Support	Part Number: D2940-1
Inspection Dwg: D2940 Rev. A1	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2940 Rev. A1/ DSK081 Rev. B & record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 <sub>9</sub>	1 <sub>10</sub>	3	4	By	Date
Lathe Section									
A	3.211	3.216		3.214	3.216				
B	4.946	4.966		4.955	4.954				
C	0.718	0.738		0.728	0.727				
D	0.090	0.110		0.110	0.110				
E	3.564	3.584		3.575	3.574				
F	0.022	0.042		0.032	0.032				
G	3.444	3.464		3.455	3.454				
H	0.112	0.132		0.121	0.121				
I	2.170	2.190		2.182	2.181				
J	4.451	4.471		4.560	4.560				
K	0.413	0.433		0.424	0.423				
L	0.913	0.933		0.922	0.924				
M									
N									
HAAS Section									
AA	0.240	0.260		.250	.250	.250	.250		
AB	0.490	0.510		.500	.500	.500	.500		
AC	0.140	0.160		.157	.156	.156	.156		
AD	3.510	3.530		3.520	3.521	3.521	3.520		
AE	1.633	1.673		1.661	1.661	1.661	1.660		
AF	1.493	1.513		1.509	1.509	1.509	1.508		
AG	0.040	0.060		.051	.051	.051	.050		
AH	0.188	0.193	DT8706	.189	.189	.188	.189		
AI	0.140	0.160		.149	.149	.149	.149		
AJ	2.518	2.538		2.528	2.528	2.527	2.528		
AK	0.040	0.060		.051	.050	.050	.050		
AL	0.010	0.020		.015	.015	.015	.015		
AM	0.140	0.160		.156	.154	.155	.155		
AN	0.350	0.450		.385	.385	.384	.385		
AO	0.240	0.260		.250	.250	.250	.250		
AP	0.150	0.170		.160	.160	.160	.161		
AQ	0.053	0.073		.063	.063	.063	.063		
AR	101.64	105.64	DT8698						
AS	0.257	0.262	DT8683	.258	.258	.258	.258		
AT	0.053	0.073		.063	.063	.063	.063		
AU	4.118	4.138		4.130	4.130	4.130	4.128		
AV									
AW									
Accept/Reject									

Measured by: SG / SA  
Date: 05/08/16 05.08.27

Audited by: 36  
Date: 05.08.27

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	



GLORIA MATERIAL TECHNOLOGY CORP.

## INSPECTION CERTIFICATE

台南縣新營市新中路35號1樓

1FL, NO.35, HSIN CHUNG RD, HSIN YING,  
TAINAN, TAIWAN, ROC

TEL: (06) 6520000

FAX: (06) 6520088

Messrs: PROGRESSIVE ALLOY STEEL UNLIMITED L.L.C.

Order No: 2004003262

Grade: 17-4PH

P.O.NO.: 3370

FILE NO: 2004004782-A

Size: 4-1/2"

Date: 11/30/2004

HEAT-Lot No: S2301-40

Weight: 1026.0KG

P'cs: 3

Condition: HF-Solution Annealed-Peeled

## Chemical Composition (wt%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Cu	Nb+Ta
Min.					0.015	3.00	15.00		3.00	0.15
Max.	0.07	1.00	1.00	0.040	0.030	5.00	17.50	0.50	5.00	
Result	0.03	0.36	0.64	0.021	0.023	4.48	15.79	0.13	3.25	

## Mechanical Properties Spec.

	Hardness (1/2R)	Grain Size	$\delta$ -Ferrite	H900-Hardness (Avg)
Spec. Min.				40HRC
Spec. Max.	363HB		5%	47HRC
Result	333HB	7.5	0.64%	45.1HRC

## Tensile Test

	Elongation (A)	Tensile Strength (Rm)	Yield Strength (Rp)	Reduction of Area (Z)
Unit	%	KSI	KSI	%
Min.	10	190	170	40
Max.				
Result	20	210	184	53

## Non-Metallic Inclusions: (AMS 2303C)

	Severity	Frequency
Max.	0.35	0.4
Result	0	0

## Specification:

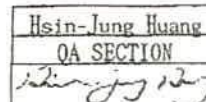
1. ASTM A484M-03a, A564M-04, A370-03a.
2. ASME SA484 (1998), SA564 (1998).
3. AMS 5643Q, 2303C (Magnetic Particle Test).
4. EN 10204/3.1.B.
5. UNS S17400.
6. SAE AMS-H-6875.

Remark:



Our quality and environment management system have been certified by ISO9001 QMS and 14001EMS  
We hereby certify that the material described herein has been manufactured and tested with satisfactory result in accordance with the requirement of  
the above material specification We hereby inspection Certificate comply with EN10204 3.1.B.

Date: 5-18-05  
Cust: Dart Aerospace  
W/O #: 153570  
Qty: 2300 Pcs.  
☒ Size ☐ Special Instructions  
☐ Part # ☒ Alloy ☐ Heat Treat  
These test reports are for material shipped  
on your order 2008035 L0FS02L  
From TMA Group & Pass Sales  
Quality Representative: [Signature]  
Customer Part #: QA Dept





GLORIA MATERIAL TECHNOLOGY CORP.

INSPECTION CERTIFICATE

台南縣新營市新中路35號1樓  
1FL., NO 35, HSIN CHUNG RD, HSIN YING,  
TAINAN, TAIWAN, ROC

TEL: (06)6520000  
FAX: (06)6520088

Messrs: PROGRESSIVE ALLOY STEEL UNLIMITED L.L.C.  
FILE NO: 2004004782-A Size: 4-1/2"  
Order No: 2004003262 Grade: 17-4PH  
HEAT-Lot No: S2301-40 Weight: 1026.0KG  
Condition: HF-Solution Annealed-Peeled

Date: 11/30/2004  
P.O.NO.: 3370  
P'cs: 3

1. MANUFACTURING PROCESS: EAF+LHF+VOD, FORCED OR HOT ROLLED.
2. SOLUTION TREATMENT: 1900F FOR 30 MIN/INCH PLUS ONE ADDITIONAL HOUR (MINIMUM ONE HOUR), RAPIDLY COOLED TO BELOW 90F.
3. MATERIAL IS FREE FROM KNOWN CONTACT WITH MERCURY AND RAIUM.
4. MATERIAL IS FREE FROM WELDS OR WELD REPAIRS.
5. ULTRASONIC TEST: OK.
6. MACRO/MICRO OK.
7. MECHANICAL PROPERTIES TESTED AS PER H900 CONDITION.
8. REDUCTION RATION 4:1 MIN
9. FURNACES CALIBRATED TO MIL-H-6875.



Our quality and environment management system have been certified by ISO9001 QMS and 14001EMS.  
We hereby certify that the material described herein has been manufactured and tested with satisfactory result in accordance with requirement of  
the above material specification. We hereby Inspection Certificate comply with EN10204 3.1 B.

Hsin-Jung Huang  
QA SECTION  
*[Signature]*